

Work Order ID 138997-2

Friday, November 20, 2015 1:27:26 PM

138997

Rush Delivery Page 1

Item ID: D3720-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step Spacer

Stop *NS2*

Start Date: 11/13/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: NOV 20 2015

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3720

Rev A

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.02

FLOW CNC Waterjet

1-Cut as per Dwg D3720

Dwg Rev: AProg Rev: A

2-Deburr if necessary

23

0215/12/16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

23

0215/12/16

Friday, November 20, 2015 1:27:26 PM

Page 2

Stop *NR2*

Quality Control

(23) 15.12.17 PD.

23x _____ 15/12/21 DAS
36
9-89

② 15-12-21

Work Order ID 138997

Friday, November 20, 2015 1:27:26 PM

138997

Page 3

Item ID: D3720-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 11/13/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								

23 15-12-22

23x 15/12/22

23x 15/12/22

DAS
36
9-89

DAS
36
9-89

Work Order ID 138997

138997

Page 4

Friday, November 20, 2015 1:27:26 PM

Item ID: D3720-2 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Step Spacer
Start Date: 11/13/2015 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 11/13/2015 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.03							
Quality Control									

ML5 JAN 28 2016

16-1-27

Picklist Print

Friday, November 20, 2015 1:27:31 PM

Page 1

Work Order ID: 138997

138997

Parent Item: D3720-2

D3720-2

Parent Item Name: Step Spacer

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		110	sf	113,4700	0.085	1.789474			

M6061T6S 125

6061-T6 .125 Sheet

**

pc 15/12/16

Location

Loc Qty

Loc Code

MAT020

113.46995

m127454

2.3

m130745

31.99995

m131352

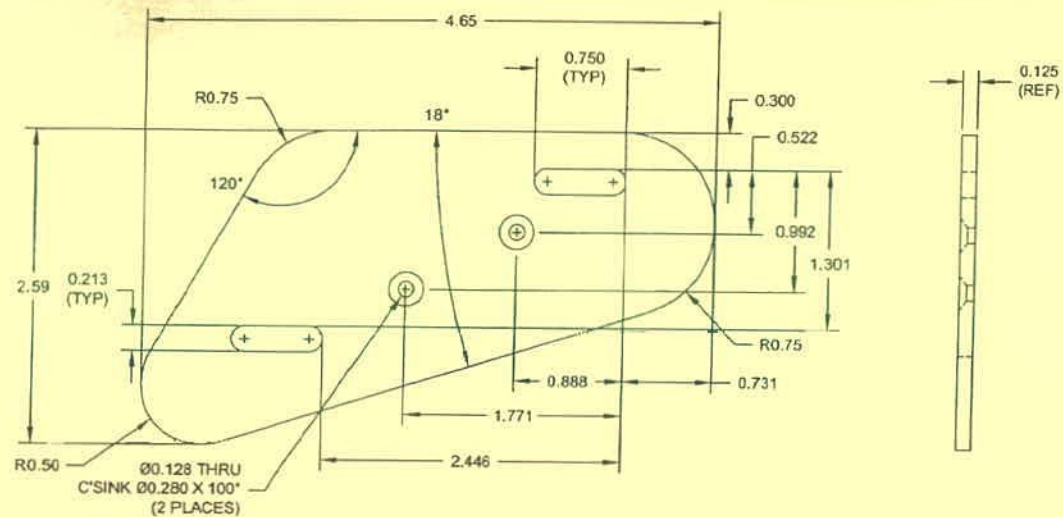
51.7

m132876

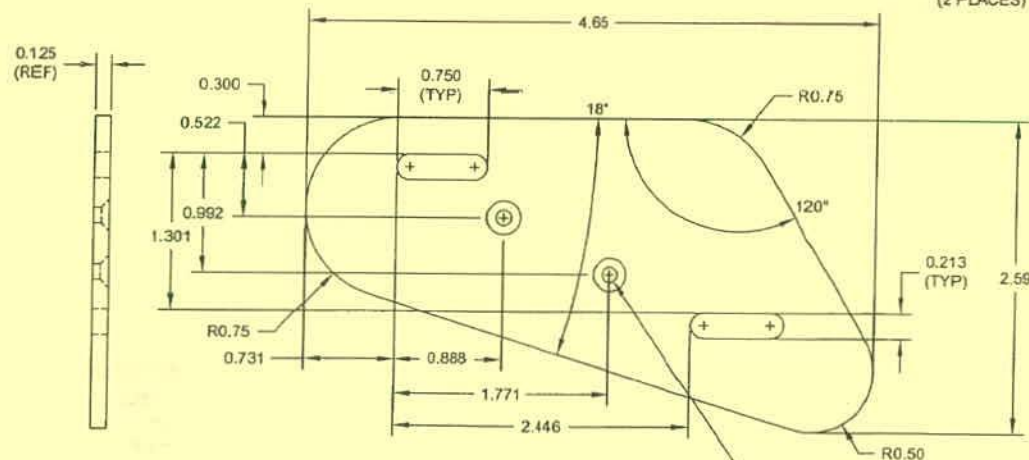
27.47

2

138997 MJS
15-11-17



D3720-1 STEP SPACER



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED
BY: ID

REV.	NEW ISSUE	PH	07.12.27
DESIGN	DESCRIPTION	BY	DATE
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3720 TITLE STEP SPACER SCALE 1:1 REV. A SHEET 1 OF 1 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE SAME BASIS AS RECEIVED. IT IS NOT TO BE USED FOR ANY PURPOSE FOR WHICH IT WAS NOT DESIGNED OR FOR WHICH IT WAS NOT DESIGNED OR FOR WHICH IT WAS NOT DESIGNED OR FOR WHICH IT WAS NOT DESIGNED.			